

Work Order ID 85112***85112***

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Friday, June 01, 2012 4:05:04 PM

Item ID: PB67-43001-45

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Longgitudinal Support

Start Date: 6/1/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *mf*Date: *12-06-04* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001

c

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1- Align drill -97 and -357 using existing pilot hole of -357 as per dwg

2- install spring pin

①

Ø

Ac
12.06.13

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

S. S. S. S. S.

④

120

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

120

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:30
320 OF
*3:00**IX**mf*
*12/06/18**W18144*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

1 ϕ 12.06.18

146

Small Fab

0.00

140

Small Fab

Memo

0.00

Small Fab

Assemble parts as per dwg

1 ϕ 12.06.19

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

8.27.06.19

xc

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: _____

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

*Ref 6/20 @**12/6/21**#1206-20*

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W/O:		WORK ORDER CHANGES					
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" Picklist Print "

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Page 1

Work Order ID: 85112

Parent Item: PB67-43001-45

Parent Item Name: Longitudinal Support

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-07-25 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-97 Clevis		Manufactured	No			100	Each	3.0000	1	1		12.06.13	

Location

Loc Qty

Loc Code

ST444

3

41869

3

PB67-43001-357

Manufactured No

Tube Arm

100 Each 10.0000

Location

Loc Qty

Loc Code

Mezz

10

41508

10

240-107

Purchased No

SPRING SLOTTED PIN

100 Each 82.0000

Location

Loc Qty

Loc Code

ST400

82

115827

82

D3447-1

Manufactured No

Round Spacer

140 Each 0.0000

D3447-5

Manufactured No

Clevis

140 Each 14.0000

Location

Loc Qty

Loc Code

ST440

14

41459

14

30345T21

Purchased No

LANYARD

140 Each 37.0000

Location

Loc Qty

Loc Code

ST401

37

17828

37

① B41458 Ae 12.06.13

~~B41221~~ ① Ae 12.06.13

Ae 12.06.13

①

W/O:		WORK ORDER CHANGES					
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Work Order ID: 85112

Parent Item: PB67-43001-45

Parent Item Name: Longgitudinal Support

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

AN4-13A Purchased No 140 Each 1,261.0000 1 1 Ae 12.06.13
Bolt

Location	Loc Qty	Loc Code
ST357	1261	
119449	33	
120187	19	
120422	2	
<u>120770</u>	207	
121652	1000	

BSP43 Purchased No 140 Each 55.0000 1 1 Ae 12.06.13
RIVET

Location	Loc Qty	Loc Code
ST284	55	
<u>110704</u>	50	
111127	5	

MS17984-C410 Purchased No 140 Each 13.0000 1 1 Ae 12.06.13
QUICK PIN REPLACEMENT

Location	Loc Qty	Loc Code
ST314	13	
<u>111119</u>	7	
18118	6	

MS21042L4 Purchased No 140 Each 3,910.0000 1 1 Ae 12.06.13
Nut

Location	Loc Qty	Loc Code
ST300	3910	
119075	116	
121011	537	
<u>121444</u>	2957	
121652	300	

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Shop Packet Print

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Parent Item Name: Longgitudinal Support

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0416J

Purchased

No

140

Each

206.0000

2

2

Washer

Ac 12.06.13

Location

Loc Qty

Loc Code

ST297

205

120833

5

120910

200

ST298

1

119124

1

NAS1149DN416J

Purchased

No

140

Each

113.0000

1

1

Washer

Ac 12.06.13

Location

Loc Qty

Loc Code

ST297

113

114597

43

13910

70

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Shop Packet Print

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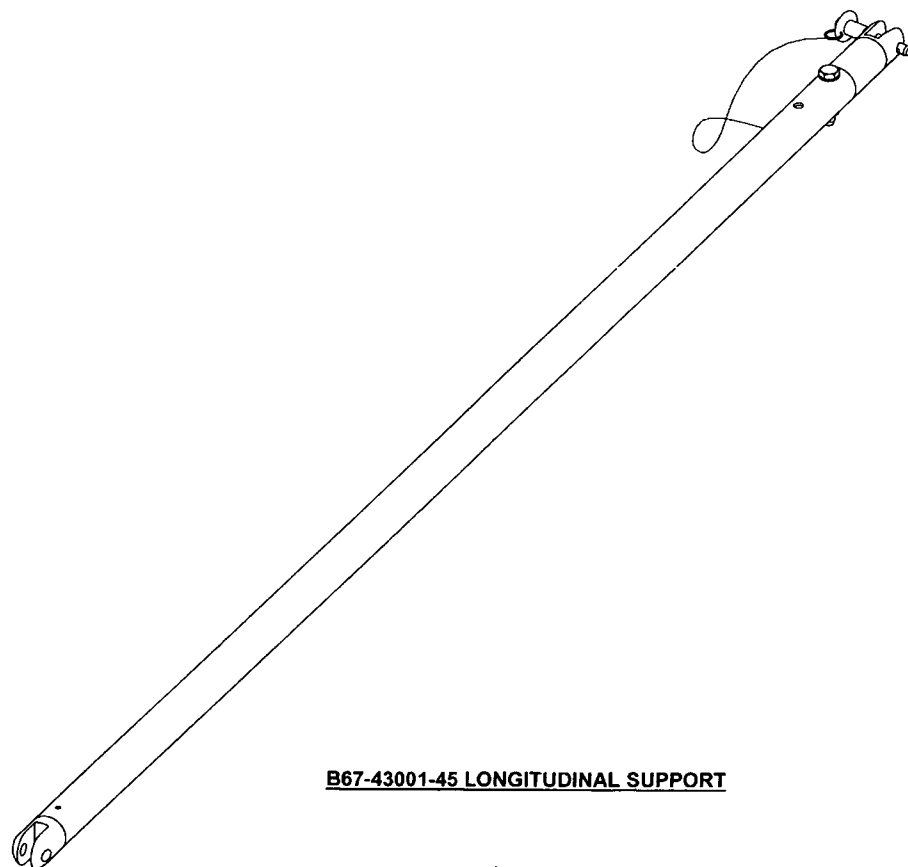
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



B67-43001-45 LONGITUDINAL SUPPORT

ITEM	QTY -45	P/N	DESCRIPTION
1	X	B67-43001-45	LONGITUDINAL SUPPORT
3	1	B67-43001-97	CLEVIS
4	1	B67-43001-357	TUBE ARM
5	1	D3447-1	ROUND SPACER
6	1	D3447-5	CLEVIS
8	1	30345T21	LANYARD
9	1	AN4-13A	BOLT
10	1	CR3213-4-2	RIVET (OR BSP43-2)
11	1	MS17984-C410	QUICK RELEASE PIN
12	1	MS21042L4	NUT
13	1	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)
14	2	NAS1149D0416J	WASHER
15	1	NAS1149DN416J	WASHER

85112

RELEASED
2009-08-24

C		REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 13 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.25
REV.	DESCRIPTION			BY	DATE
DESIGN	RW			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RW			REV. C	
CHECKED	ASS			DRAWING NO. B67-43001-45	
MFG. APPR.	AP			SHEET 1 OF 2	
APPROVED	AP			TITLE LONGITUDINAL SUPPORT	
DE APPR.	N/A			SCALE NTS	
DATE	09.06.25			COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

B67-43001-97
2 CLEVIS

B67-43001-357
2 TUBE ARM

10 CR3213-4-2 RIVET
NAS1149DN416J WASHER
(30345T21 LANYARD NOT SHOWN
ON THIS VIEW FOR CLARITY)

D3447-1
ROUND SPACER

AN4-13A BOLT
NAS1149D0416J WASHER, 2X
MS21042L4 NUT

MS17984-C410
QUICK RELEASE
PIN

10 30345T21 LANYARD

0.50

8

MS171534 2 8
SPRING SLOTTED TENSION PIN

9

D3447-5
CLEVIS

2 PL

B67-43001-45 LONGITUDINAL SUPPORT

RELEASED
2009-09-24

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.99 lbs
- 8) PRIOR TO POWDER COAT, ALIGN B67-43001-97 ON B67-43001-357 AS SHOWN AND DRILL A $\varnothing 0.129$ HOLE THROUGH BOTH PARTS.
- 9) FASTEN B67-43001-97 TO B67-43001-357 USING MS171534 SPRING SLOTTED PIN.
- 10) MASK PRIOR TO POWDER COAT
- 11) BEFORE OR AFTER POWDER COAT, DRILL A $\varnothing 0.129$ HOLE IN B67-43001-357 TO INSTALL THE LANYARD. DRILL THROUGH ONE WALL ONLY.
- 12) AFTER POWDER COAT, INSTALL 30345T21 LANYARD ON B67-43001-357 AS SHOWN USING CR3213-4 TYPE RIVET AND NAS1149DN416J WASHER.

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AD	B67-43001-45	SHEET 2 OF 2
APPROVED	TH	TITLE	SCALE
DE APPR.	N/A	LONGITUDINAL SUPPORT	
DATE	09.06.25	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
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